

Work Order ID 115507

April-02-14 11:14:37 AM

115507

Page 1

Item ID: D3391-023

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Mid Tube Assembly

Stop

NS2

Start Date: 4/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-02 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

100

Skidtubes

Skidtubes

Memo

1-Cut tube to finish length as per Dwg D3391

2-Drill pilot holes using DT8796 (Do not drill B holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

3-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

4-Remove .030" from Fwd indexing Ridge as per Dwg D3391

5-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

6-Deburr

7-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG

8-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (10 holes) as per Dwg D3391

9-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

DO NOT OPEN 2 MOST FWD WEARPLATE HOLES

SCRAP

DEC

14-4-21

DEC

14-4-21

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Reference:

Approvals:

Process Plan: _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run

Start

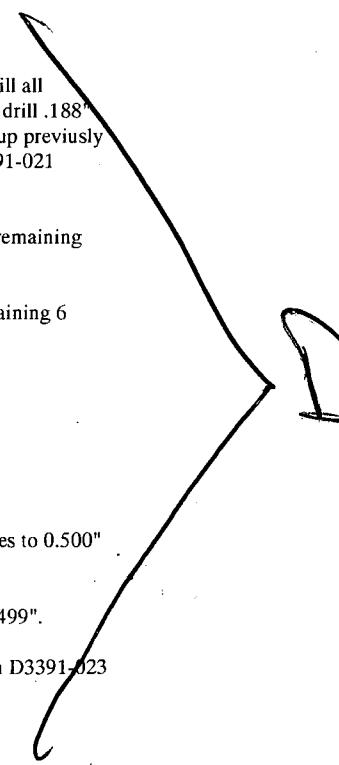
NR1

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
		10-Open .375" holes to .438" ***do not open fwd saddle holes***	DG	14-4-21					
		11-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)							
		12- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect alignment, open up previously transfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021							
		D3391-021 BATCH: <u>114259</u>							
		13- Using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.							
		14- Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplate holes in D3391-021 using DT8937							
		15- Open 10 wearplate holes in D3391-021 to 0.297" dia.							
		16- insert D3391-021 into D3391-23							
		17- insert T-pins into first and third fwd saddle holes							
		18- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per							
		19- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499".							
		20-Deburr and blow out all chips from inside tube, scribe batch # in D3391-023 at aft end.							



DP

14-4-22

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Revision ID:						
Item Name:	Mid Tube Assembly					*NS2*
Start Date:	4/02/14	Start Qty: 1.00	*1*	Cust Item ID:		
Required Date:	4/16/14	Req'd Qty: 1.00	*1*	Customer:		

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	SMP						
	Memo	0.00	14/4/23						
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00	14-4-28	JL	DCL				
	Memo	0.00							
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat	0.00				1	0	04/04/28	
	Memo	0.00							

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Stop

NS2

Start Date: 4/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

140

Skidtubes

Skidtubes

Memo

0.00

1-Open float bag holes as per dwg
2-C'sink float bag holes as per dwg
3- Prepare tube for welding
4-Bond web in place as per Dwg D3391 & QSI 015.
Adhere for 12 hours
A/R Sikaflex exp: 14/04/09
batch#: 128026

NOTE: ENSURE WEB IS INSERTED IN AFT END OF TUBE

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Quality Control

Memo

0.00

DAS
18
8-89

DC 14/04/28

1 0 14-04-30

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Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Skidtubes	Skidtubes	0.00							
	Memo	0.00							
	1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush - <i>De 14/04/20</i>		A/R m12 8385	AE14-04-30					
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00	<i>SH</i>	<i>14/S/C</i>					
	Memo	0.00							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	<i>SH</i>	<i>14/S/6</i>					
	Memo	0.00							

PTO
Last page

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1

Cust Item ID:

Required Date: 4/16/14 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Quality Control

Memo

0.00




Picklist Print

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D3391-023

Parent Item: D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.10.20 New Issue KJ/EC
IPP B06.02.10 ECN773 dwg rev.D EC
IPP C 07.03.20 rev F dwg EC
IPP D 07.03.28 re-format EC
IPP E 07.10.31 ecn 1053P EC
IPP Rev:F ECN 1056 07-11-13 DD verified by: EC
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP
Rev:J add in seq 140 expire date & b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100		Manufactured	No			100	Each	83.0000	1	1			

D2500-1-100

Skidtube Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	83	
82373	22	
86065	61	

D3389-1

D3389-1

Web

D3681-1

D3681-1

• 3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	168	
114884	168	
LG001	66	
109109	66	

Picklist Print

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D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3591-1

Manufactured No

Each 88.0000

2

*********D3591-1***

Bushing

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FG	10	
	92873	10	
	FP001	78	
	100699	5	
	107918	36	
	109107	37	

ALS4-1032-130

AEALS4-1032-130 Purchased

No

230

Each

9,937.000

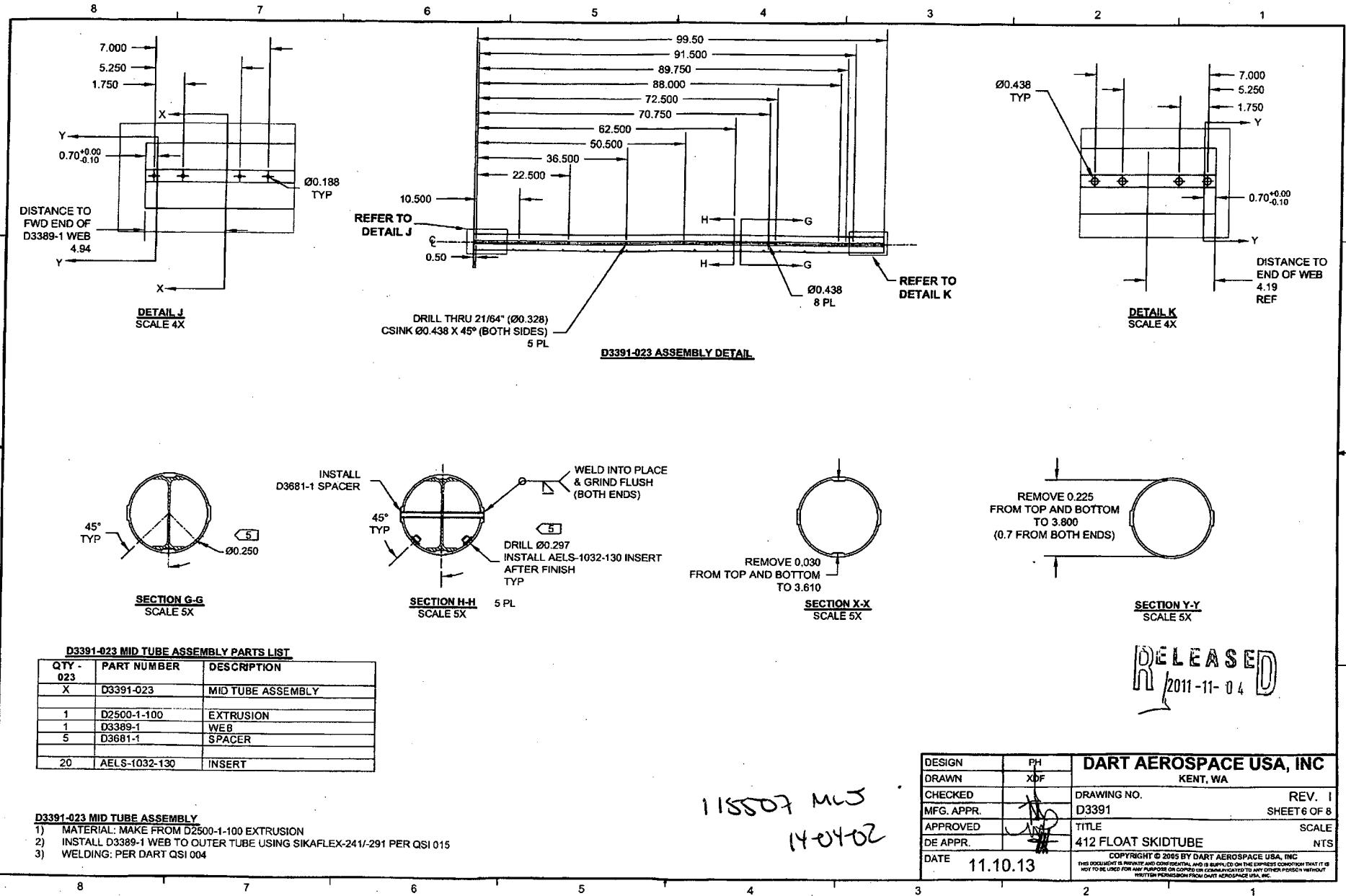
20

20

*********AI S4-1032-130***

Rivnut

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	9832	
	M128649	9832	
	ST279	48	
	M128211	48	
	st510	57	
	M126109	57	



NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AJ Date: 14/12/13QA Closed: SAJ Date: 14/12/11

Work Order: <u>115507</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D 3391-023</u>	Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input checked="" type="checkbox"/>		
NCR No. <u>NCR 14-4110</u>	Pax/Ly:						

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator	<u>14/7/16</u>		<u>1</u>	<u>DEEP CORROSION IN OUTER SURFACE.</u> <u>PART WAS STORED IN ALUDIUM/ACID Room TOO LONG</u> <u>Re Parts were not kept in a clean area.</u>	<u>DAS 12 9-89</u> <u>14/7/16</u>	<u>SCRAP.</u> <u>AND DESTROY</u> <u>No Replk.</u>	<u>14-8-16</u> <u>14-8-16</u>	<u>DAS 16 9-89</u>	
Material									
Setup									
Other	<input checked="" type="checkbox"/>								
Process									
Supplier									
Training									
Unapproved									

POOR House Keeping (Facility issue) FAULT CATEGORY

Landing Gear	General				
Bending	Bend				
Centre Not Concentric to O/S	BOM/Route				
Cracks	Broken/Damaged				
Crushed/Crimped.	Burrs				
Cuffs	Contamination				
Heat Treat	Countersink				
Inspection Strip in Tube	Cut Too Short				
Ripples in Bend	Drill Holes				
Torque Waves in Extrusion	Drawing				
Turning Sequence	Finish				
Wave/Twist in Tube	Folio				
	Grain	Ovalized	Pressure/Forced		
	Hardware	Over/Under tolerance	Temperature/Cure		
	Inspection Incomplete	Part Incorrect	Weld		
	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled		
	Maintenance	Part Moved			
	Mislabeled	Positioned Wrong			
	Misread	Power Loss/Surge			
	Offset	<u>Facility</u>			
	Out of Calibration				
	Out of Sequence				
	Outside Dimensions				